



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2432

Job Sheet 169430



Part No: D2432

Job Qty: 22 ea

Part Name: Bearpaw 19" X 24"



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/11/17

Job Tracking No:

Due Date: 12/21/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Great Slave Helicopters Ltd (CGREA01)

Accounting Office, 6285 Airport Way Kelowna, BC, V1V 1S1 Canada ph:(403) 286-2040 fx:(250) 765-0077.

Note: DWG REV H IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	22 Ea	12/19/17	12/19/17	0.00	0.00	Start Up Container		DC 17/12/12
120	Waterjet	22 pcs	12/19/17	12/19/17	0.00	5.67	Waterjet1		DC 17/12/12
130	CNC Vertical Machining	22 pcs	12/21/17	12/21/17	0.36	28.24	HAAS 1		SC 17/12/20
140	QC	22 pcs	12/21/17	12/21/17	0.00	0.00	QC2		SC 17/12/20
150	QC	22 pcs	12/21/17	12/21/17	0.00	0.00	QC8		SC 17/12/20
160	Packaging	22 pcs	12/21/17	12/21/17	0.00	0.00	Packaging3	STC/SLA S	
170	QC21-SA	22 Ea	12/21/17	12/21/17	0.00	0.00	QC21		DEC 21 2017

Part Op 120 - Cut Blank as per D2432 File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10	81	1,048	0	0

Part Specifications

Specifications could not be found.

Plex 12/12/17 1:41 PM dart.lacelle.linda

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework ☐		Skid tube ☐	
NCR No. _____		Scrap ☐		Therm ☐	
Date : _____		Use-as-is ☐		Engineering ☐	
Step #: _____		Suspected Unapproved ☐		Quality ☐	
Description Work Order Deviation				Other ☐	
				SI042) Approval ☐	
				Completed By _____	
				id / Supervisor _____	
				al Verification _____	
				Coordinator _____	
				proval _____	
				ed Wrong _____	
				Dimensions _____	
				der tolerance _____	
				rrect _____	
				'Missing _____	
				ed _____	
				Turning Sequence _____	

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 CANADA
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 www.dartaerospace.com

D2432

Start up Operation

Mfg Date: 12/12/17
Job No: 169430

DART
AEROSPACE

S020979

Bearpaw 19" X 24"

PART NO:

Revision:

Operation:

Change No:

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced ☐

Bending ☐

Centre Not Concentric ☐

Cracks ☐

Crimp/Kink/Ripple/Wave ☐

Cuffs ☐

Crushing ☐

Heat Treat ☐

Wave/Twist in Tube ☐

Marks/Chatter, ☐

Temperature ☐

Set-up ☐

BOM/Route ☐

Broken/Dam ☐

Inspection In ☐

Contaminatic ☐

Countersink ☐

Cut Too Short ☐

Instructions Ir ☐

Drill Holes ☐

OTHER : _____

DART AEROSPACE LTD		Work Order:	169430
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: H		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		Ver	EDC
B	0.200	+/-0.030	0.190	✓		Ver	EDC
C	0.25 x 45°	+/-0.030	0.25 x 45°	✓		TAPE	
D	R0.250	+/-0.030	0.250	✓		R.G.	
E	0.250	+/-0.010	0.245	✓		Ver	EDC
F	0.625	+/-0.030	0.623	✓		Ver	EDC
G	0.375	+0.030/-0.010	0.383	✓		Ver	EDC
H	0.950	+/-0.030	0.950	✓		Ver	EDC
I	19.000	+/-0.030	19.000	✓		TAPE	
J	Ø0.260	+0.005/-0.000	0.260	✓		Ver	EDC
K	Ø0.93	+/-0.030	0.929	✓		Ver	EDC
L	0.30	+0.030/-0.000	0.312	✓		Ver	EDC
M	23.750	+/-0.030	23.750	✓		TAPE	
N	2.000	+/-0.030	2.015	✓		Ver	EDC
O	0.38	+/-0.030	0.380	✓		Ver	EDC
P							
Q							
R							
S							
T							
U							
V							

Measured by: SC. [Signature]	Audited by: [Signature]	Preliminary Approval:
Date: 17/12/19	Date: 17-12-20	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	[Signature]

